

Work Order ID 138587-2

138587

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Tuesday, November 03, 2015 11:45:42 AM

Item ID: D2230-3

Accept

Revision ID:

Item Name: Mounting Lug

Start Date: 11/3/2015 Start Qty: 100.00

Required Date: 11/3/2015 Req'd Qty: 100.00

Reference:

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MCS Date: NOV 03 2015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2230	Rev G								
110	Outsource process - Machining	0.00							
110	HAAS CNC VERTICAL MACHINING #1								
Outsource5	Memo	0.00							
Outsource process - Machining	Issue P/O to Metec : <u>30361</u>								
	Machine as per dwg								
	C of C is required								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.03							
Packaging	Ensure C of C is attach								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.00							
Quality Control									

CZ NOV 04 2015 100

SP 50X SP15-12-10

(50) 15-12-16

DAS
9
9-89

16

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Tuesday, November 03, 2015 11:45:42 AM

Item ID: D2230-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Mounting Lug
 Start Date: 11/3/2015 Start Qty: 100.00 ***100*** Cust Item ID:
 Required Date: 11/3/2015 Req'd Qty: 100.00 ***100*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	N/A						
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 0.02							
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							
START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____									

DAS
9
9-89

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Tuesday, November 03, 2015 11:45:42 AM

Item ID: D2230-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mounting Lug
 Start Date: 11/3/2015 Start Qty: 100.00 *100* Cust Item ID:
 Required Date: 11/3/2015 Req'd Qty: 100.00 *100* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC3- Inspect Part Finish <i>Memo</i> <i>N/A</i>	0.00 0.02 <i>DAS 9 9-89</i>							
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <i>ST525A</i> <i>Memo</i>	0.00 0.02				<i>SD</i>		<i>DAS 8 9-89</i>	<i>JAN 2 1 2016</i>
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release <i>Memo</i>	0.00 0.17				<i>ML5</i>			<i>JAN 2 2 2016</i>

ML5 JAN 2 2 2016

Picklist Print

Tuesday, November 03, 2015 11:45:46 AM

Page 1

Work Order ID: 138587

138587

Parent Item: D2230-3

D2230-3

Parent Item Name: Mounting Lug

Start Date: 11/3/2015

Required Date: 11/3/2015

Start Qty: 100.00

Required Qty: 100.00

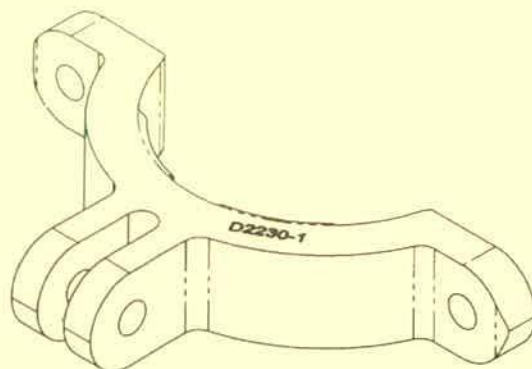
Comments: IPP D00.05.18 Added inspection level 8, and removed P/O for powder coatEC
25 JLM VERIFIED BY:EC IPP REV :E NEW FOLIO # 10-05-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P		Purchased	No				Each	0.0000		100			
D2230-3P									**				
Lug													
D2423		Manufactured	No				f	425.6395		7.189474			
D2423									**				
Lug Extrusion													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Metec		425.6395151							
					127892	119.689515							
					131451	305.95							

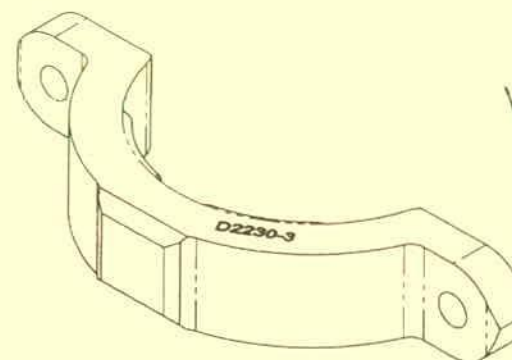
50x 8p15-12-10

CL NOV 04 2015

✓



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

138587 ML

15-11-03

RELEASED
9/16/15 MP



NOTES:

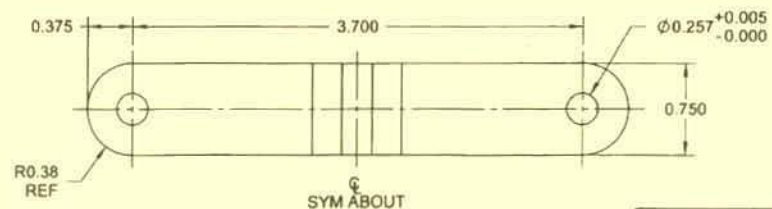
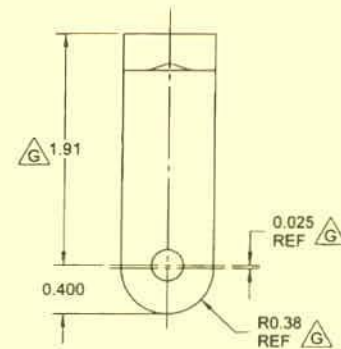
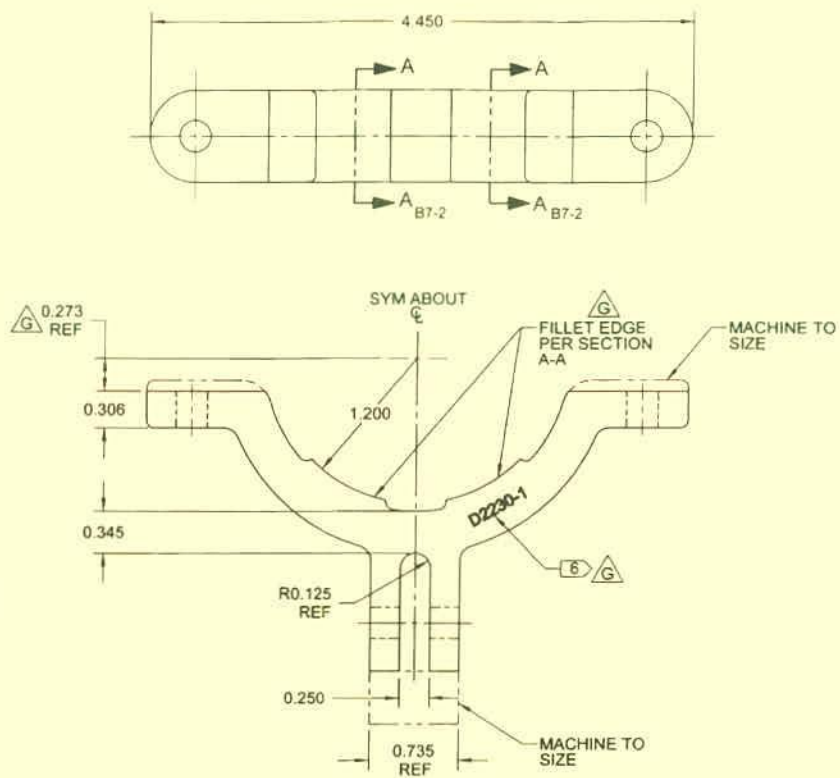
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

Q	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED BY THE EXPRESS CONSENT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SECTION A-A D4-2
SCALE 2X



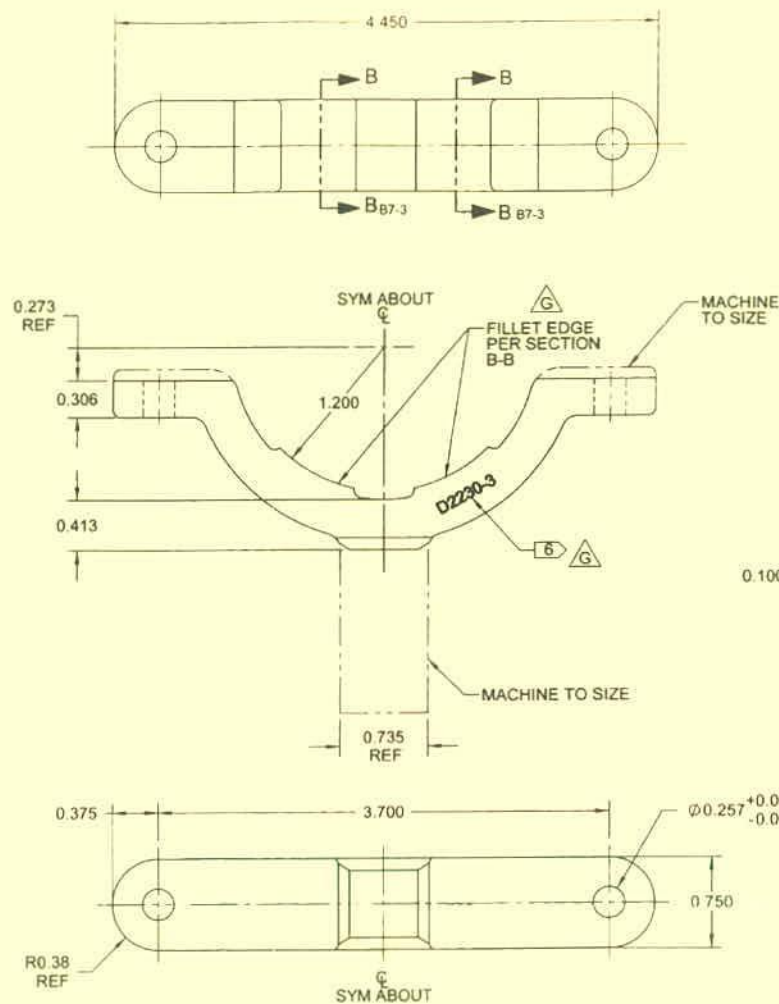
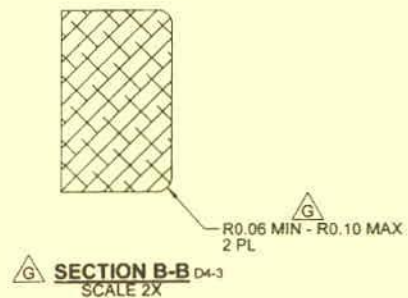
R0.06 MIN - R0.10 MAX
2 PL



D2230-1 MOUNTING LUG

RELEASED
09/06/25/14

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D2230-3 MOUNTING LUG

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2230	REV. G SHEET 3 OF 3
MFG APPR.		TITLE MOUNTING LUG	SCALE NTS
APPROVED		COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	
DE APPR.			
DATE	09.01.16		

RELEASED
09/06/25



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO30361

Purchase Order Date 11/4/2015

PO Print Date 11/4/2015

Page Number 1 of 2

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2230-1P	Lug	11/26/2015 Yes 11/26/2015		50.00 Each	\$16.10	\$805.00

AS PER DWG D2230 REV. G
B138586
ALODINE AND DPAINT AS PER QSI 005

Line Total: \$805.00

2	D2230-3P	Lug	11/26/2015 Yes 11/26/2015	FN	100.00 Each	\$13.80	\$1,380.00
---	----------	-----	---------------------------------	----	----------------	---------	------------

AS PER DWG D2230 REV. G
B138587

Line Total: \$1,380.00

Note:

11/4/2015

*Rec'd 40x
Rec'd 50x
\$15.1210
2015-11-11*



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 20846
Date: Dec 03, 2015
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 30361	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: Dec 03, 2015

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3235-1 Mounting Lug as per drawing D3235 Rev.A Alodine and Paint as per QSI005	Each	50		
D2230-1 Mounting Lug as per drawing D2230 Rev.G Alodine and Paint as per QSI005	Each	50		
D2230-3 Mounting Lug as per drawing D2230 Rev.G Alodine and Paint as per QSI005	Each	100	50	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY
50

PART NUMBER
D2230-3 ✓

PART NAME
Lug Batch#127892 Paint#20211

P.O. NUMBER
30361

MATERIAL: supplied by DART

SP15-12-10
We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, December 3, 2015